

Work Order ID 68026

Tuesday, April 05, 2011 1:14:52 PM



Page 1

Item ID: D3264-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 4/5/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 11/04/05 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3264	Rev A2

100

0.00



Bandsaw

Memo

CUT BLANK 5.700" LONG

0.00

Jeaspa Bandsaw

Handwritten: 11/04/06
B.A. 11/04/11

10

1

110

0.00



HAAS 1

Memo

MACHINE AS PER FOILIO FA447

FOILIO REV: AA

DWG REV: A

DEBURR AS PER DWG

0.00

HAAS CNC vertical machine #1

Handwritten: B.A. 11/04/07

10

1

Handwritten: P167

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3264-1 PAR #: N/A Fault Category: Machining NCR: Yes No DQA: A Date: 11.04.21
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ✓ Date: 11/04/25

NCR: <u>68026</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/04/11</u>	<u>110</u>	<u>1 part scrap due to a tool that scored the part .045" deep in floor area during a tool change.</u> <u>R.C Machine tool changer malfunction</u>	<u>11.04.12</u> <u>OSI042</u>	<u>→ Dropped the Z origin by .045" the floor is ok but the .063" lip is no longer within tolerances</u> <u>SCRAP + REPLACE.</u> <u>B/W: 112628</u>	<u>M.A</u> <u>11/04/11</u>	<u>11/04/12</u>	<u>11.04.12</u> <u>OSI042</u>	<u>11/04/18</u>

NOTE: Date & initial all entries

Work Order ID 68026

Tuesday, April 05, 2011 1:14:52 PM



Page 2

Item ID: D3264-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 4/5/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B.A 11/04/07

10

1

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

C.R. 11/04/12

10

4

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10

BR 11-4-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68026

Tuesday, April 05, 2011 1:14:52 PM



Page 3

Item ID: D3264-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 4/5/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

START 3:55
OVERT. 3:00
FINISH 4:25

0.00

Powder Coating

10 BL 11-4-13

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 11/04/14

170

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

11/4/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68026

Tuesday, April 05, 2011 1:14:52 PM



Page 4

Item ID: D3264-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 4/5/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/18
MF
11-04-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, April 05, 2011 1:14:49 PM

Page 1

Work Order ID: 68026

Parent Item: D3264-1

Parent Item Name: Bracket



Start Date: 4/5/2011

Required Date: 4/15/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A 04.09.02 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X04.50 0		Purchased	No				f	17.0000		5			



6061-T6 Bar 1.25 X 4.50

Location

Loc Qty

Loc Code

MAT004

17

112628

17

5 *ml 11/04/06*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	68026
Description: Bracket		Part Number:	D3264-1
Inspection Dwg: D3264	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	0.690	✓		Vern	GA-01
0.063	+/-0.010	0.063	✓		"	"
0.125	+/-0.010	0.124	✓		"	"
0.875	+0.010/-0.020	0.875	✓		"	"
0.062	+/-0.010	0.062	✓		"	"
R0.03	+/-0.030	R0.032	✓		R-G	ref.
R0.13	+/-0.030	R0.125	✓		"	"
1.00	+/-0.030	1.001	✓		Vern	GA-01
0.125	+/-0.010	0.125	✓		"	"
0.600	+/-0.010	0.600	✓		"	"
4.000	+/-0.005	4.000	✓		"	"
0.750	+/-0.010	0.749	✓		"	"
Ø0.194	+0.005/-0.000	Ø0.197	✓		"	"
5.50	+/-0.030	5.500	✓		"	"
0.125	+/-0.010	0.125	✓		"	"
0.063	+/-0.010	0.065	✓		Mic	118-120
R0.25	+/-0.030	R0.250	✓		R-G	ref.
4.27	+/-0.030	4.270	✓		Vern	GA-01
R0.30	+/-0.030	R0.300	✓		R-G	ref.

Measured by:	KA
Date:	11/04/07

Audited by:	<i>[Signature]</i>
Date:	11/04/12

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	
C	07.10.10	Tolerance for 0.875 revised	KJ/EC/DD	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

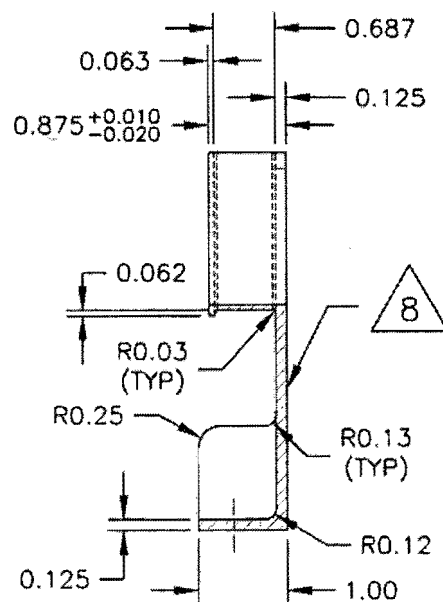
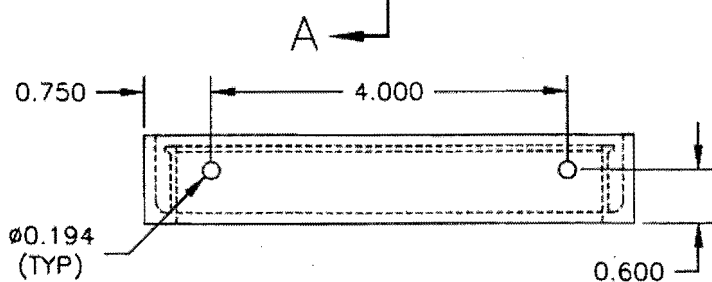
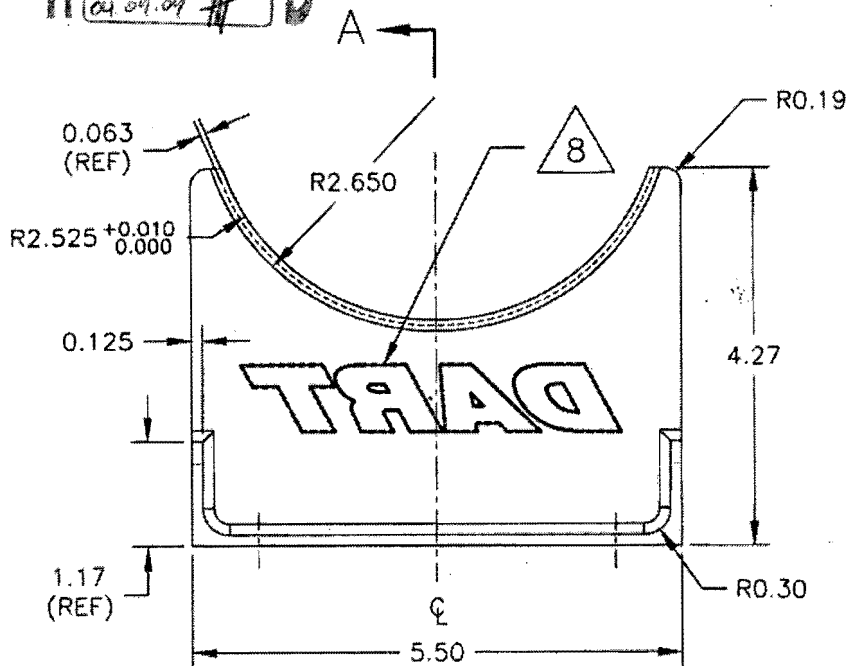
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

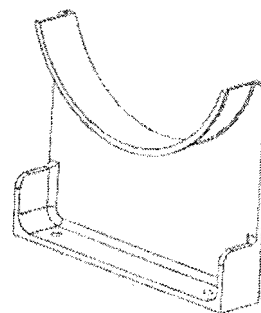


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED JH	DRAWING NO. D3264	REV. A SHEET 1 OF 1
DATE 04.04.20		TITLE BRACKET	SCALE 1:2
A	04.04.20	NEW ISSUE	

RELEASED
04.09.09 JH



SECTION A-A



D3264-1 BRACKET

D3264-1:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

CD 11/04/05

WID. 68026

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries